

Defect 1st 200

Work Order ID 121684

Thursday, June 26, 2014 3:06:52 PM

121684

Page 1

Item ID: D3455-3

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Spacer

Stop

NS2

Start Date: 6/26/14

Start Qty: 10.00

10

Cust Item ID:

Required Date: 6/26/14

Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 14-06-30

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D3455	Rev A
-------	-------

100

100

Hardinge

Hardinge CNC Lathe Small

Hardinge CNC LATHE SMALL
1-TURN AS PER FOLIO FA584 & DWG D3455 ,FOLIO
REV: A DWG REV: A

2-DEBURR AS REQUIRED

DAS
02
9-89

14.07.21

X23

110

110

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

DAS
02
9-89

14.07.21

120

120

QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

23

Ø

DAS
44
9-89

14/07/21

closed
W/Mach opalce

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only

Work Order: _____	DISPOSITION			AGAINST DEPARTMENT/PROCESS						
Part No. _____	Rework	<input type="checkbox"/>	Skid-tube	<input type="checkbox"/>	Crosstube	<input type="checkbox"/>	Water Jet	<input type="checkbox"/>	Engineering	<input type="checkbox"/>
NCR No. _____	Scrap	<input type="checkbox"/>	Machining	<input type="checkbox"/>	Small Fab	<input type="checkbox"/>	Prod. Eng. Coor.	<input type="checkbox"/>	Quality	<input type="checkbox"/>
	Use-as-is	<input type="checkbox"/>	Thermoforming	<input type="checkbox"/>	Finishing	<input type="checkbox"/>	Rec/Store/Packaging	<input type="checkbox"/>	Other	<input type="checkbox"/>
	Suspected Unapproved	<input type="checkbox"/>	Large Fab	<input type="checkbox"/>	Composite	<input type="checkbox"/>	Supplier	<input type="checkbox"/>		

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY									
Landing Gear		General							
		Bending	Bend	Folio/Program	Outside Dimensions	Pressure/Forced			
		Centre Not Concentric	BOM/Route	Grain	Over/Under tolerance	Set-up			
		Cracks	Broken/Damage/Defect	Hardware	Part Incorrect	Temperature/Cure			
		Crimp/Kink/Ripple/Wave	Burrs	Inspection Incomplete/Unqualified	Part Lost/Missing	Weld			
		Cuffs	Contamination	Instructions Incomplete/Unclear	Part Moved	Wrong Stock Pulled			
		Crushing	Countersink	Misaligned/off center	Positioned Wrong				
		Heat Treat	Cut Too Short	Mislabeled	Power Loss/Surge	Other			
		Inspection Strip in Tube	Drawing	Misread					
		Marks/Chatter	Drill Holes	Off-set					
		Turning Sequence	Finish	Out of Calibration					
		Wave/Twist in Tube	Fit/Function	Out of Sequence					

Work Order ID 121684

Thursday, June 26, 2014 3:06:52 PM

121684

Page 2

Item ID: D3455-3

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Spacer

Stop

NS2

Start Date: 6/26/14

Start Qty: 10.00

10

Cust Item ID:

Required Date: 6/26/14

Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

150

Identify as per dwg & Stock Location:

STO39

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

0.00

0.00

23X

14-7-21

DAS
26
9-89

150

Packaging

Packaging

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Quality Control

Memo

0.00

14/7/2014

440722

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____

Date: _____

Work Order update only

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework Scrap Use-as-is Suspected Unapproved

AGAINST DEPARTMENT/PROCESS

Skid-tube Machining Thermoforming Large Fab Crosstube Small Fab Finishing Composite Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier Engineering Quality Other

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear	General				
Bending	Bend				
Centre Not Concentric	BOM/Route				
Cracks	Broken/Damage/Defect				
Crimp/Kink/Ripple/Wave	Burrs				
Cuffs	Contamination				
Crushing	Countersink				
Heat Treat	Cut Too Short				
Inspection Strip in Tube	Drawing				
Marks/Chatter	Drill Holes				
Turning Sequence	Finish				
Wave/Twist in Tube	Fit/Function				
	Folio/Program				
	Grain				
	Hardware				
	Inspection Incomplete/Unqualified				
	Instructions Incomplete/Unclear				
	Misaligned/off center				
	Mislabeled				
	Misread				
	Off-set				
	Out of Calibration				
	Out of Sequence				

Picklist Print

Thursday, June 26, 2014 3:06:51 PM

Page 1

Work Order ID: 121684

121684
D3455-3

Parent Item: D3455-3

Parent Item Name: Spacer

Start Date: 6/26/14

Required Date: 6/26/14

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV. A 05.11.17 NEW ISSUE EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDELRINR1.000		Purchased		No		100	f	3.3830	0.022	0.231579			
MDFI RINR1 000					129774		x 0.3		**	DAS 02	85	14 - 07 - 21	

Delrin Round Bar 1" color: black

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT039	3.383	
m128667	3.383	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only

Work Order: _____	DISPOSITION			AGAINST DEPARTMENT/PROCESS					
Part No. _____	Rework	Scrap	Use-as-is	Skid-tube	Crosstube	Water Jet	Engineering		
NCR No. _____	Suspected	Unapproved		Machining	Small Fab	Prod. Eng. Coor.	Quality		
				Thermoforming	Finishing	Rec/Store/Packaging	Other		
				Large Fab	Composite	Supplier			

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear		General									
Bending		Bend		Folio/Program		Outside Dimensions		Pressure/Forced			
Centre Not Concentric		BOM/Route		Grain		Over/Under tolerance		Set-up			
Cracks		Broken/Damage/Defect		Hardware		Part Incorrect		Temperature/Cure			
Crimp/Kink/Ripple/Wave		Burrs		Inspection Incomplete/Unqualified		Part Lost/Missing		Weld			
Cuffs		Contamination		Instructions Incomplete/Unclear		Part Moved		Wrong Stock Pulled			
Crushing		Countersink		Misaligned/off center		Positioned Wrong					
Heat Treat		Cut Too Short		Mislabeled		Power Loss/Surge					
Inspection Strip in Tube		Drawing		Misread							
Marks/Chatter		Drill Holes		Off-set							
Turning Sequence		Finish		Out of Calibration							
Wave/Twist in Tube		Fit/Function		Out of Sequence							

DART AEROSPACE LTD	Work Order:	<u>121684</u>
Description: Spacer	Part Number:	<u>D3455-3</u>
Inspection Dwg: D3455 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

DAS

Measured by: <i>RT</i>	DAS 02	Audited by: 44 9-89	Prototype Approval: N/A
Date: 14-07-21		Date: 14/07/21	Date: N/A

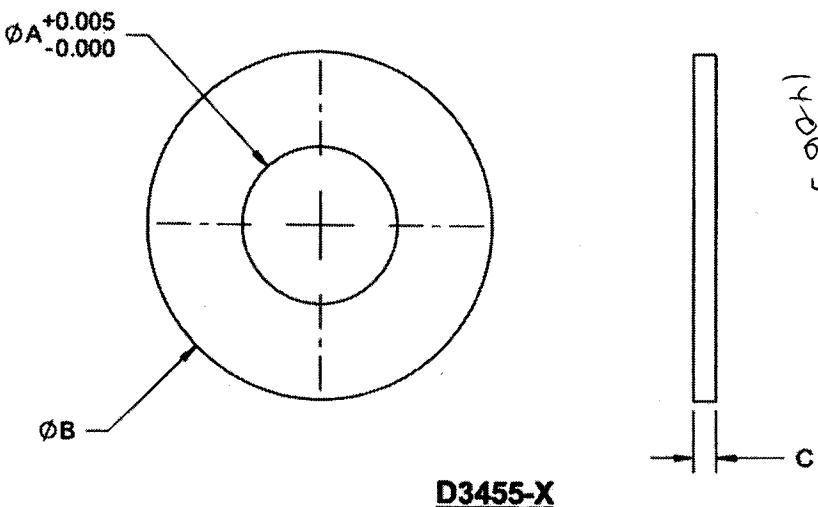
Rev	Date	Change	Revised by	Approved
A	06.07.11	New Issue	KJ/JLM	E

DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D3455	REV. A SHEET 1 OF 1
DATE 05.09.02	TITLE SPACER	SCALE 2:1	
A	05.09.02	NEW ISSUE	

RELEASED05.12.09 *[initials]*

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 121684 M5
1400-30

**1) SPECIFICATION: D3455-X SPACER**

—
DASH No.

WHERE 'X' IS THE SIZE PER THE FOLLOWING TABLE:

DASH No.	A (in)	B (in)	C (in)
-1	0.453	1.00	0.065
-3	0.386	1.00	0.050

NOTES:

- 1) MATERIAL: DELRIN ROUND BAR (REF. DART SPEC. M-DELRIN-R)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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